



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW109-3101-58-1-1
Job Sheet 197404



Part No: RBW109-3101-58-1-1

Job Qty: 8 pcs

Part Name: Hammer, Steel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 9/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBW109-3101-58-1 Rev3 IPP Rev A 17.11.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	8 pcs	9/2/19		0.00	8.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	8 pcs	9/2/19		0.00	0.00	QC 5 - 10		DAS 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	B4B	8 pcs	9/2/19		0.00	0.00	Packaging 3 - 1 - B4B		JUL 17 2019
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		

DART AEROSPACE
Container No: S197909
Part: RBW109-3101-58-1-1
Job No: 197404
Serial No/Batch: S197909
Revision: 3
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 07/15/19

					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	8 pcs	9/2/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Joe M

GA 102

21 JUL 19 2019

Part Op 100 - Small Fab - 1-Assemble as per DWG RBW109-3101-58-1 Sheet 2 2-Epoxy -5 shaft into -3 hammer head and -7
 Descriptions: handle -LOCTITE 620 M 5166705 EXP; 11/01/20 ***8hr. cure time*** Start time 11:25 am End time 12:00 pm (next day)

110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW109-3101-58-1-3	Hammer Head	8 pcs (1 ea)	100-Small Fab - 1	115128750 7K 5183701
RBW109-3101-58-1-5	Shaft	8 pcs (1 ea)	100-Small Fab - 1	4K 5183835 4K 5173419
RBW109-3101-58-1-7	Handle	8 pcs (1 ea)	100-Small Fab - 1	5185273

Job Allocations

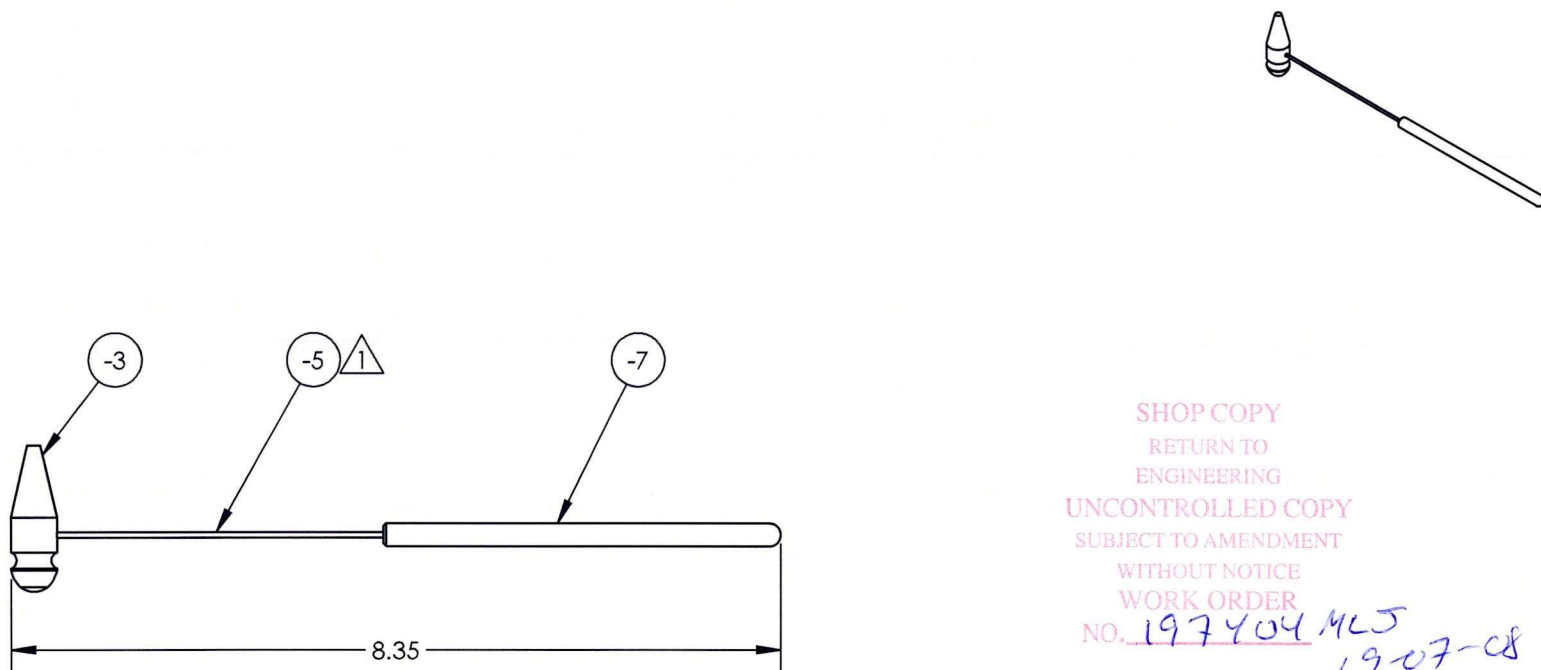
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RBW109-3101-58-1-3	8	31	0
	RBW109-3101-58-1-5	8	25	0
	RBW109-3101-58-1-7	8	59	0

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0212	-1 CH'D DWG TO SHEET METAL TOLERANCE.	11/4/2016	RJC	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 197404 MLS
19-07-08

NOTE:

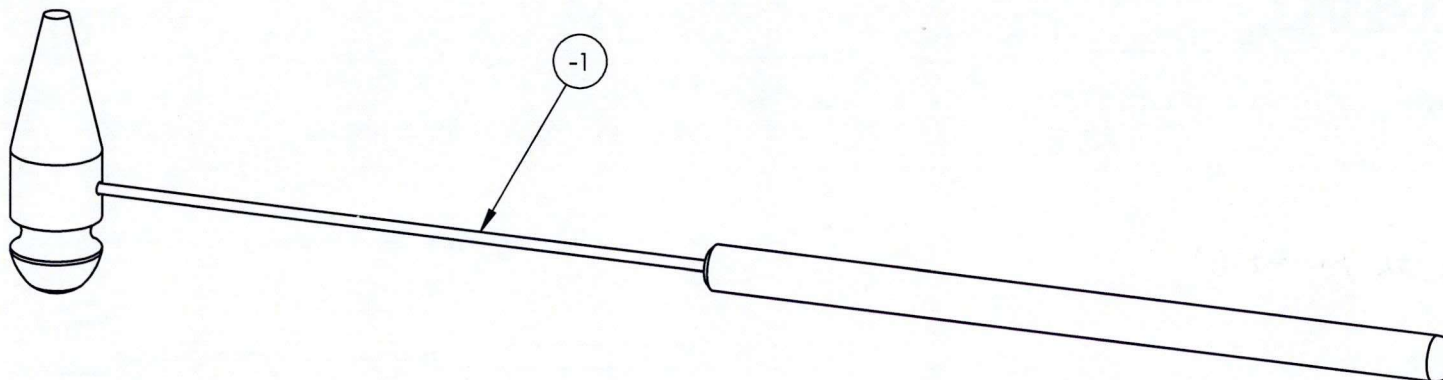
1 EPOXY -5 SHAFT INTO -3 HAMMER HEAD & -7 HANDLE.

(-1)
HAMMER, STEEL

DART AEROSPACE	
TITLE HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION	
DWG NO. RBW109-3101-58-1-1	REV 3
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .010 FRACTIONS ± 1/8
FINISH	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW109/AW119
SCALE 1:2	DATE 3/12/2015 SHEET 2 OF 5

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	6/1/2015	DPD	JAG
2	16-0212	ADDED NOTE 2 SHEET 1. -1 CH'D DWG TO SHEET METAL TOLERANCE. -3 CH'D FINISH WAS CAD PLATE YELLOW IS ZINC PLATE ASTM B633 TYPE 1 SC 2, CH'D MATERIAL WAS 1018/1020 IS 1018/1020 CR. -5 CH'D DIM WAS S(Ø.059) IS (Ø.060/.058). -7 CH'D DIM WAS Ø.24 IS Ø.25, CH'D ENGRAVE NOTE WAS LASER ENGRAVE T/N IS LASER ENGRAVE T/N, S/N, "MADE IN USA".	11/4/2016	RJC	JAG
3	17-0053	-7 CH'D ENGRAVE NOTE WAS LASER ENGRAVE T/N, S/N, "MADE IN USA" IS LASER ENGRAVE T/N.	2/20/2017	RJC	JAG



NOTE:

1. REF. AGUSTA T/N: 109-3101-58-1.
2. -1 USED IN KITS: RBT18025, RBEA62309, RBT18510, & RBT18561.

TEO ATTACHED

DART AEROSPACE																											
TITLE HAMMER, STEEL, BLADE CORROSION AND VOIDS DETECTION																											
DWG NO. RBW109-3101-58-1	REV 3																										
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td></td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY: DUERFELDT</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>CHECKED: DUERFELDT</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>USED ON MODEL</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>AW109/AW119</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td></td> </tr> <tr> <td>SCALE 1:1</td> <td>DATE 3/12/2015</td> </tr> <tr> <td colspan="2">SHEET 1 OF 5</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8		.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125/	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	DRAWN BY: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	OPPS APPR: ANDERSON	USED ON MODEL	QA APPR: LINDSAY	AW109/AW119	APPROVED: GILBERT		SCALE 1:1	DATE 3/12/2015	SHEET 1 OF 5	
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APPROVED: GILBERT																											
SCALE 1:1	DATE 3/12/2015																										
SHEET 1 OF 5																											

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	HAMMER, STEEL			2
	1		-3		HAMMER HEAD	1018/1020 CR		3
	1		-5		SHAFT	S.S.	Ø.059 X 1 FT. (MCMaster-CARR #8908K62) MODIFIED	4
	1		-7		HANDLE	6061		5
		B/O	-9	1	CASE	PLASTIC	SMALL PISTOL CASE (RSR GROUP #10137)	N/S
	ASSY -1							

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					